

Work Order ID 132456

132456

Page 1

Item ID: D3371-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Tail Rotor Pedal Lock

Stop

NS2

Start Date: 5/07/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3371

Rev B

120

0.00

120

Small Fab

Small Fab

Memo

0.00

Small Fab

ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.

2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.

3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5

4- Assemble lock mechanism and cam and install decal as per Dwg D3371.

Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	<u>M132102</u>

M132102

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

JUN 25 2015

JUN 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

May-07-15 2:44:33 PM

Page 1

Work Order ID: 132456

132456

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

238-028		Purchased	No			120	Each	109.0000	2	2			
238-028									**			FF	JUN 08 2015
3/16" Dowel Pin .5" long													

Location	Loc Qty	Loc Code
ST568	109	
108114	11	
M132062	98	

AN526C832R6		Purchased	No			120	Each	72.0000	4	4			
AN526C832R6									**			FF	JUN 08 2015
Screw													

Location	Loc Qty	Loc Code
ST	72	
m131379	72	

D3371-1		Manufactured	No			120	Each	3.0000	1	1			
D3371-1									**			FF	JUN 08 2015
Pedal Lock Base													

Location	Loc Qty	Loc Code
ST498	3	
109067	1	
70040	2	

D3371-3		Manufactured	No			120	Each	6.0000	1	1			
D3371-3									**			FF	JUN 08 2015
Pedal Lock Cover													

Location	Loc Qty	Loc Code
ST498	6	
104353	6	

DQA: _____ Date: _____



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Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 1.00

Required Qty: 1.00

D3373-7

Manufactured No

120

Each

15.0000

1

1

D3373-7

Cam Lock

FF

JUN 08 2015

Location

Loc Qty

Loc Code

ST036

15

123528

4

94791

11

D3385-3

Manufactured No

120

Each

29.0000

1

1

D3385-3

Hinge

FF

JUN 08 2015

Location

Loc Qty

Loc Code

ST036

29

117534

29

CBL-1240

Purchased No

130

f

149.1606

1.6666

2

CBL-1240

Cable

FF

JUN 08 2015

Location

Loc Qty

Loc Code

GA

149.1606

m130006

149.1606

CBL-460

Purchased No

130

Each

418.0000

2

2

CBL-460

Loop Sleeve

FF

JUN 08 2015

Location

Loc Qty

Loc Code

GA

418

m131619

418

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

May-07-15 2:44:34 PM

Page 3

Work Order ID: 132456

132456

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 1.00

Required Qty: 1.00

D3384-1 Manufactured No

130 Each 1.0000 1

D3384-1

Cyclic Sock

**

1
DAS
30
9-89

JUN 24 2015

Location

Loc Qty

Loc Code

ST500

1

B 133088

1

123313

1

HX-81 Purchased No

140 Each 71.0000 1

HX-81

1/4"-20 SHCS 3/8" long

**

1

FF

JUN 08 2015

Location

Loc Qty

Loc Code

ST554

71

123436

71

1

NAS1149F0463P Purchased No

140 Each 1,303.000 2

NAS1149F0463P

Washer

**

2

FF

JUN 08 2015

Location

Loc Qty

Loc Code

ST260a

984

m127832

984

st268

319

m127832

295

m130388

24

2

May-07-15 2:44:34 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

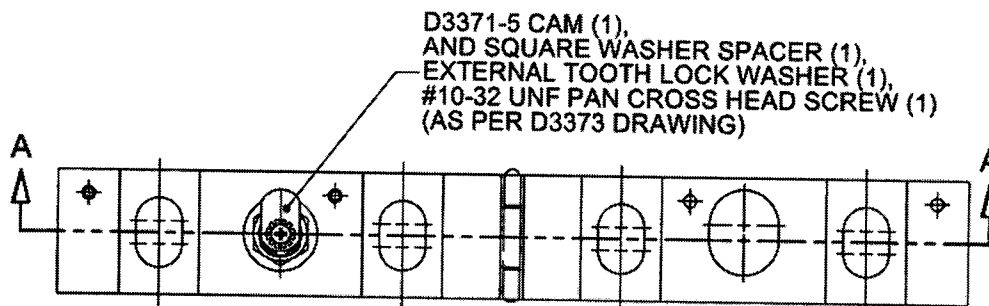
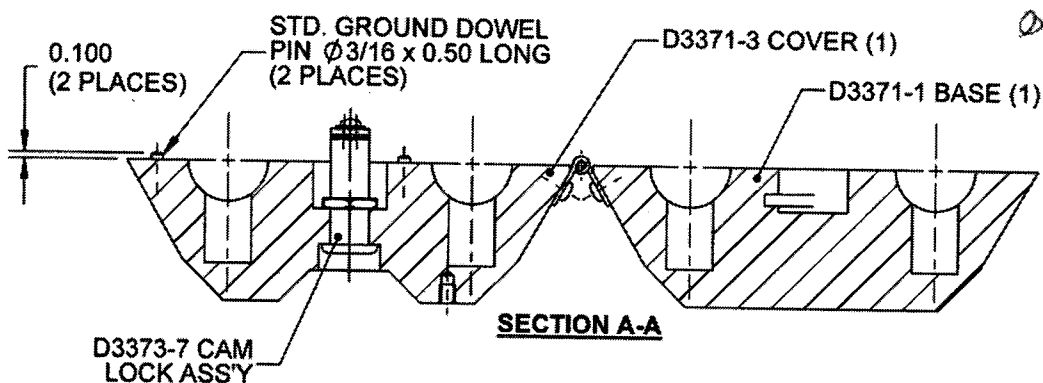
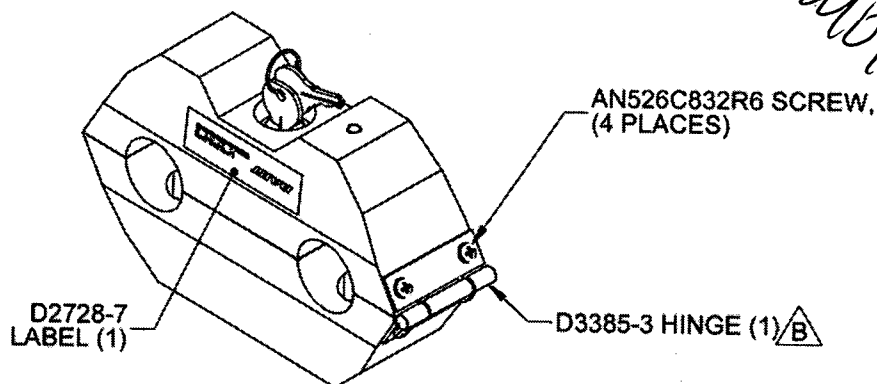
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



NOTES:

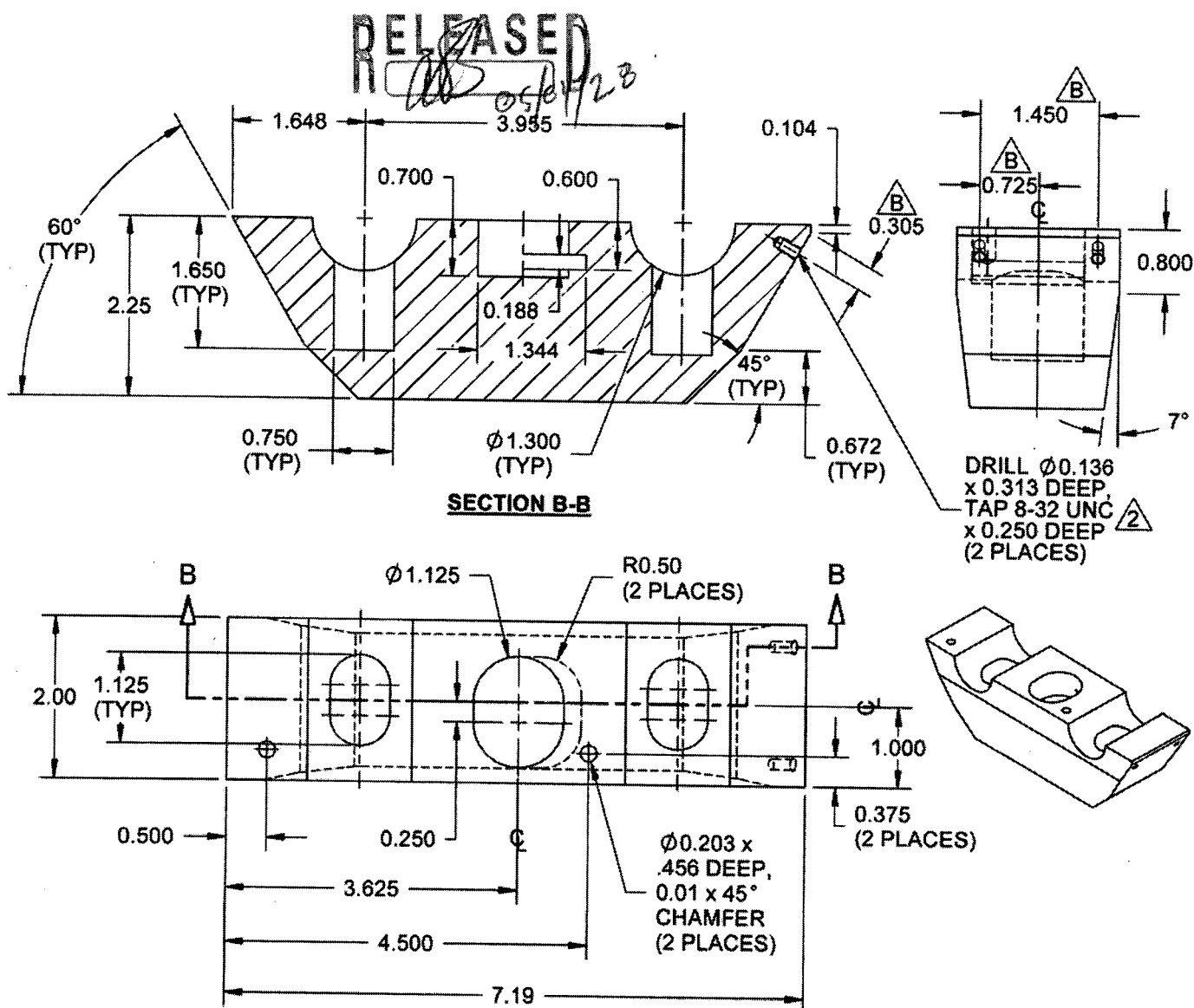
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



NOTES:

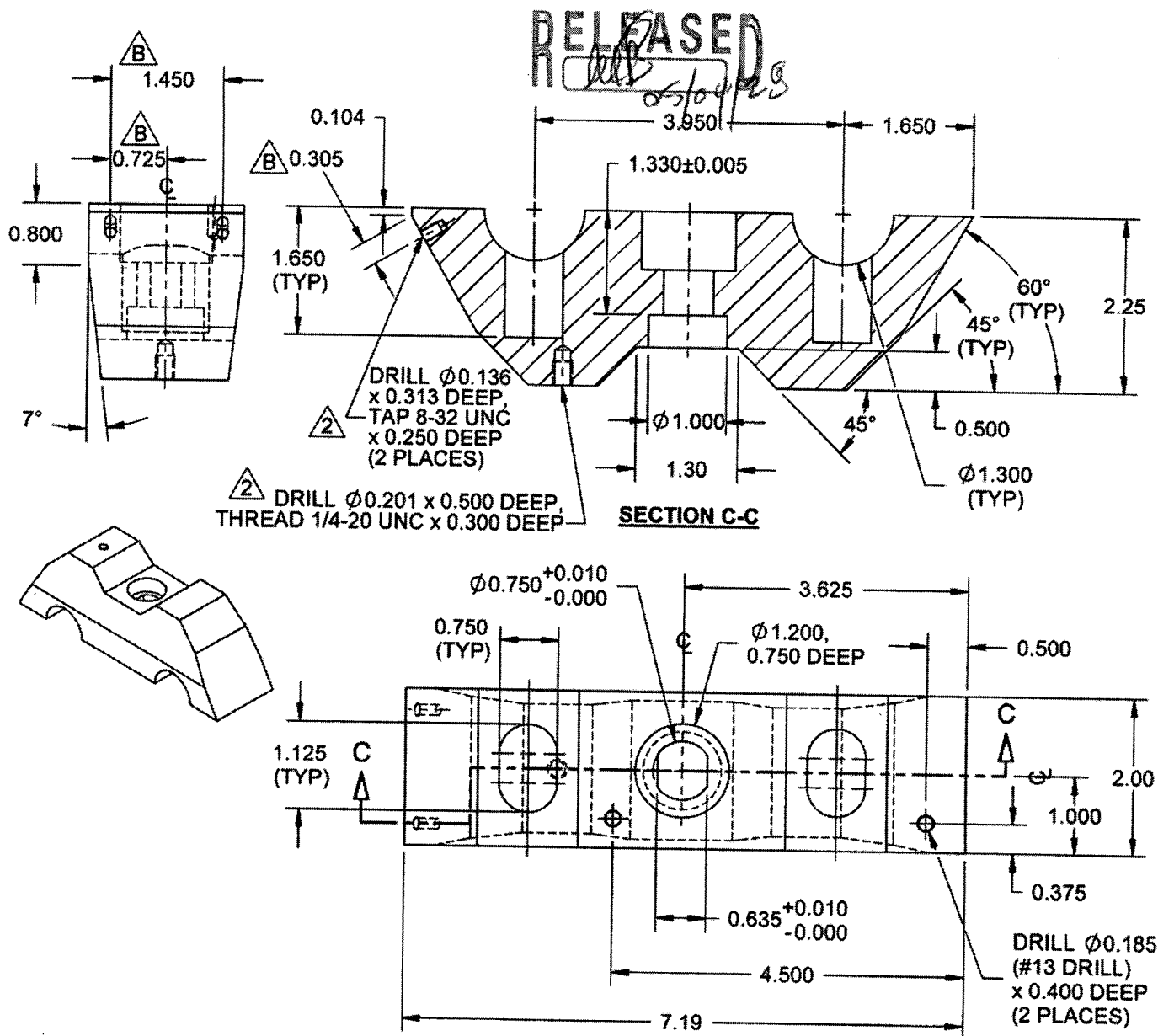
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED *	APPROVED [Signature]	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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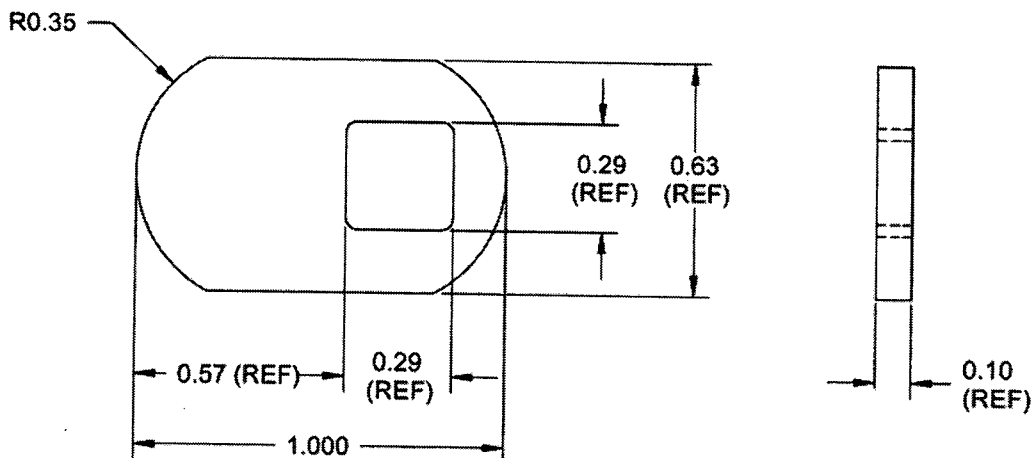
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/22

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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